



ATLANTIS-PAK

Leader In Innovative
Packaging Solutions

Films **AMISTYLE**

AMISTYLE BP/CP

FOR FLOW PACK WRAPPERS

Process Operating Manual



1. APPLICATION

This Process Operating Manual describes the procedure for packaging of food products with the use of the **AMISTYLE BP** and **AMISTYLE CP** films.

AMISTYLE BP/CP are multilayer heat-shrink vapor- and gas-tight heat-sealable films made of polyamide, polyolefin, polyethylene terephthalate, EVOH and adhesive (modified polyethylene) permitted by the Russian Ministry of Health for use in the food industry. The quality of the raw materials used for production of the film is confirmed by Russian and international quality certificates.

The **AMISTYLE BP/CP** films are manufactured according to Specifications TU 22.21.30-052-27147091-2012 and are intended for packaging of various food products (meat-based food, chilled or frozen meat, chilled or frozen poultry, sausages and specialties, chilled or frozen fish, cheeses and cheese-based products) in order to prolong the shelf life.

The **AMISTYLE BP/CP** films are suitable for processing on high-rate horizontal or vertical packaging machines, and can be used for either separate (individual) or group packages.

The shelf lives of the food products packaged in the **AMISTYLE BP/CP** films shall be set by the manufacturers and approved following the procedure stipulated by the laws.

2. PROPERTIES AND ADVANTAGES

The combination of different polymer materials in the structure of the **AMISTYLE BP/CP** films provides for:

- excellent sealability within a wide range of temperatures, and tightness of the packages to protect the products against the external factors;
- high strength to preserve the integrity of the packaged products at the stages of transportation and storage;
- attractive appearance of the packaged products thanks to high transparency and gloss;
- high barrier to oxygen and water vapor, which ensures the longest shelf life.

Thus, the combination of selected polymer materials in the film structure provides for good preservation of products, extends their shelf life, and makes it possible to wrap food products of various sizes and shapes on high-rate automatic equipment.



Absence of chlorine-containing substances makes the **AMISTYLE** film more environment-friendly, because disposal of such packaging is less harmful for the environment.

See the technical characteristics of the **AMISTYLE BP/CP** films in the Product Specifications.

3. ASSORTMENT

Table 1 – Assortment of the Amistyle films for Flow Pack wrappers

Film type	Nominal thickness, μm	Width, mm	Standard length in reel, m
Amistyle CP-40	40	200 – 1300	1000
Amistyle CP-50	50	200 – 1300	1000
Amistyle BP-60	60	250 – 470	1000
		471 - 1000	500
Amistyle BP-60	90	250 – 1000	500
Amistyle BP-110	110	250 – 1000	500

Color: clear

Marking: single-color, multi-color or CMYK printing is possible with volatile solvent-based inks.

Form of supply: reels on 76mm diameter cardboard cores.

4. FILM PROCESSING TECHNOLOGY

4.1. Film storage and transportation

4.1.1. Keep the film in closed dry rooms at a distance of not less than 800mm from heaters, in the absence of strong-smelling or corrosive substances, at the temperature from + 5 °C to + 35 °C and relative humidity not exceeding 80 %.

4.1.2. Transport the film at temperatures not exceeding 40 °C, and do not expose it to direct sunlight.

4.1.3. If the film was stored at a temperature below zero, keep it at room temperature before processing for at least 24 hours without opening the manufacturer's packing.



4.2. Food product packaging

Packaging of food products in the **AMISTYLE BP/CP** films shall be made in production rooms meeting the requirements of the applicable food safety regulations and standards.

Packaging consists in automatic heat sealing of the product inside a tight film bag.

The process of food packaging in the **AMISTYLE BP/CP** films consists in automatic forming of a tight film bag around the product, and filling of the bag with modified atmosphere.

To ensure stability of the packaging process, observe the manufacturer-recommended operating modes for the packaging equipment.

Flow Pack wrapping includes the following stages:

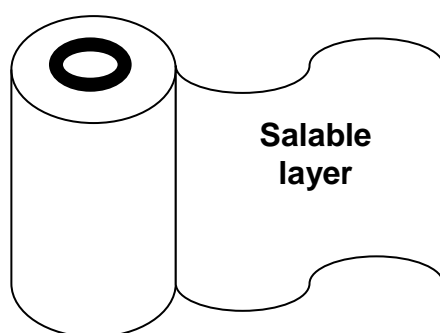
- forming of a film bag to match the product size;
- closure of the package by heat sealing;
- cutting: separation of individual bags.

4.3. Forming and sealing of bags

Loading of the film in the automatic sealing equipment must be made in accordance with the instructions of the equipment manufacturer and the loading procedure.

The **AMISTYLE BP/CP** films have a heat-sealable polyethylene (PE) layer on the inner side of the film web (Fig. 1).

Fig. 1 – Amistyle film reel



Transfer of the products to the conveyor belt feeding the products to the **AMISTYLE** film in the forming zone of the packaging machine can be made either manually, or automatically; see to that the product size matches the film width. Take care to prevent the product getting into the film sealing zone, because this may lead to loss of vacuum.

Take care to maintain the film well-tensioned during the operation.

The equipment settings (sealing temperature, packages per minute rate, etc.) shall be selected on a case-by-case basis.

The seals must be even and continuous, bearing a clear imprint of the sealing bar, without any signs of burn-through.

If the sealing quality is unsatisfactory, check the temperature settings.

The sealing temperature for the **AMISTYLE BP/CP** films varies depending on the product size and shape, the equipment operation rate and film thickness, and lies within the range of 130 – 150 °C (on the sealing rollers and sealing lips).

Dwell time on sealing lips: 1-2 seconds.

To ensure stability of the packaging process, observe the manufacturer-recommended operating modes for the packaging equipment.

Keep the sealing zone clean and free of any foreign inclusions; there must be no burn-through spots in the protective coating of the heating element.

When MAP is used, preset the required modified atmosphere quantity at the sealing station.

Use tightness control instruments to check the seals for tightness.

After that the packaged product may be dispatched for weighing, labeling and storage.

4.4. Transportation and storage of products

The products packaged in the **AMISTYLE BP/CP** films shall be transported and stored in accordance with the standard documentation applicable to the product (GOST, TU).

5. MANUFACTURER'S GUARANTEES

The shelf life of the **AMISTYLE BP/CP** film is 2 years from manufacture to processing, subject to compliance with the transportation and storage requirements for the user's warehouse, and provided that the manufacturer's packing remains intact.

6. APPENDICES

There are no appendices to this document.





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